



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G15231-3G

Job Sheet 189620



Part No: RBW6205G15231-3G

Job Qty: 1 pcs *2 MLL*

Part Name: AW139 Swashplate Box 1



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G15231-3G REV 1 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/15/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		<i>MLL</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	4/15/19		0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		<i>MLL</i>
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	1 pcs	4/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Container No: S165144



Part: RBW6205G15231-3G

Job No: 189620

Serial No/Batch: S165144

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/22/19

DAS
40
9-89

MAR 26 2019

Plex 2/11/19 4:31 PM Dart.Hadley.Shannon

				QC 5 - 30	
130 Packaging 3-1 - Stock - B4B	1 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/15/19	0.00 0.00	QC 21 - FG - 21	DAS 21
				QC 21 - FG - 70	9-00
				QC 21 - SA - 53	MAR 26 2
Part Op 100 - Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican Strom case IM-2875-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6205G15231-3G-9 to RBW6205G15231-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.					
110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican Strom case IM-2875-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6205G15231-3G-9 to RBW6205G15231-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.					
120 - (QC5- Inspect part completeness to step on W/O)					
130 - (Identify as per dwg & Stock Location:_____)					
140 - (QC21- Final Inspection - Work Order Release)					

MLC

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21
9-00

MAR 26 2019

RB001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
IM2875-E	Pelican Case	1 Ea (1 ea)	100-Small	
4611T26 <i>86</i>	Cup	4 <i>2</i> Ea (2 ea)	Fab - 1	<i>3164132</i>
90183A213 <i>63</i>	BLIND RIVET FLAT WASHER ALUMINUM, ROUND, FOR 1/8" RIVET BODY DIA., 3/8" OD	8 <i>4</i> Ea (4 ea)	110-Small	<i>3150507</i> <i>41 Broken</i>
97447A130 <i>38</i>	Aluminum Blind Rivet W/Aluminum Mandrel Domed, 1/8" Dia., 0.313"-0.375" Material Thickness	8 <i>4</i> Ea (4 ea)	Fab - 2 - B4B	<i>3058755</i>
AN5-10A <i>51338</i>	Bolt	16 <i>8</i> Ea (8 ea)	110-Small	<i>3054330</i>
AN5-27A <i>5337</i>	Bolt 5/16 X 2 31/32 Steel	8 <i>4</i> Ea (4 ea)	Fab - 2 - B4B	<i>3149326</i>
AN960-516 <i>51322</i>	WASHER SEE PART NAS1149F0563P	16 <i>8</i> pcs (8 ea)	110-Small	<i>3057095</i>
RB41011	Dart Tooling Placard, Aluminum	2 <i>1</i> Ea (1 ea)	110-Small	<i>3156677</i>
RBW6205G11451-3G	Clamp	16 <i>8</i> pcs (8 ea)	Fab - 2 - B4B	<i>3041158</i>
RBW6205G11651-3G	Guide	1 Ea (1 ea)	110-Small	<i>3021040</i>
RBW6205G11751-3G	Guide	1 pcs (1 ea)	Fab - 2 - B4B	<i>3160812</i>
RBW6205G15231-3G-5	Bottom Foam use in case IM2875-E	1 Ea (1 ea)	110-Small	<i>3141123</i>
RBW6205G15231-3G-7	Lid Foam use in case IM2875-E	1 Ea (1 ea)	Fab - 2 - B4B	<i>3058370</i>
RBW6205G15231-3G-9	Inside Placard	1 Ea (1 ea)	110-Small	<i>3164128</i>
RBW6205G15551-3G	Pin	1 pcs (1 ea)	Fab - 2 - B4B	<i>3164130</i>
				<i>3158869</i>
				<i>3154869</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	IM2875-E	1	3	0
110-Small Fab - 2 - B4B	4611T26	2	16	0
	90183A213	4	487	0
	97447A130	4	96	0
	AN5-10A	8	232	0
	AN5-27A	4	14	0
	AN960-516	8	270	0
	RB41011	1	417	0
	RBW6205G11451-3G	8	16	0
	RBW6205G11651-3G	1	11	0
	RBW6205G11751-3G	1	7	0
	RBW6205G15231-3G-5	1	3	0
	RBW6205G15231-3G-7	1	3	0
	RBW6205G15231-3G-9	1	3	0
	RBW6205G15551-3G	1	1	0

Part Specifications

Specifications could not be found.

Plex 2/11/19 4:14 PM Dart.Hadley.Shannon

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Job Sheet 189620



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Type: SOLD

Description:

Note: DWG RBW6205G15231-3G REV 1 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	4/15/19		0.00	0.00	Small Fab - 1		
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							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	4/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
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							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

Plex 1/29/19 8:42 AM Dart.lajeunesse.marie

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	4/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican Strom case IM-2875-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6205G15231-3G-9 to RBW6205G15231-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location:_____) 140 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
4611T26	Cup	2 Ea (2 ea)	110-Small Fab - 1	
90183A213	BLIND RIVET FLAT WASHER ALUMINUM, ROUND, FOR 1/8" RIVET BODY DIA., 3/8" OD	4 Ea (4 ea)	110-Small Fab - 1	
97447A130	Aluminum Blind Rivet W/Aluminum Mandrel Domed, 1/8" Dia., 0.313"-0.375" Material Thickness	4 Ea (4 ea)	110-Small Fab - 1	
AN5-10A	Bolt	8 Ea (8 ea)	110-Small Fab - 1	
AN5-27A	Bolt 5/16 X 2 31/32 Steel	4 Ea (4 ea)	110-Small Fab - 1	
AN960-516	WASHER SEE PART NAS1149F0563P	8 pcs (8 ea)	110-Small Fab - 1	
IM2875-E	Pelican Case	1 Ea (1 ea)	110-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G11451-3G	Clamp	8 pcs (8 ea)	110-Small Fab - 1	
RBW6205G11651-3G	Guide	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G11751-3G	Guide	1 pcs (1 ea)	110-Small Fab - 1	
RBW6205G15231-3G-5	Bottom Foam use in case IM2875-E	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G15231-3G-7	Lid Foam use in case IM2875-E	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G15231-3G-9	Inside Placard	1 pcs (1 ea)	110-Small Fab - 1	
RBW6205G15551-3G	Pin	1 pcs (1 ea)	110-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	4611T26	2	4	0
	90183A213	4	487	0
	97447A130	4	96	0
	AN5-10A	8	194	0
	AN5-27A	4	14	0
	AN960-516	8	270	0
	IM2875-E	1	3	0
	RB41011	1	478	0
	RBW6205G11451-3G	8	16	0
	RBW6205G11651-3G	1	11	0
	RBW6205G11751-3G	1	7	0
	RBW6205G15231-3G-5	1	3	0
	RBW6205G15231-3G-7	1	3	0
	RBW6205G15231-3G-9	1	3	0
	RBW6205G15551-3G	1	1	0

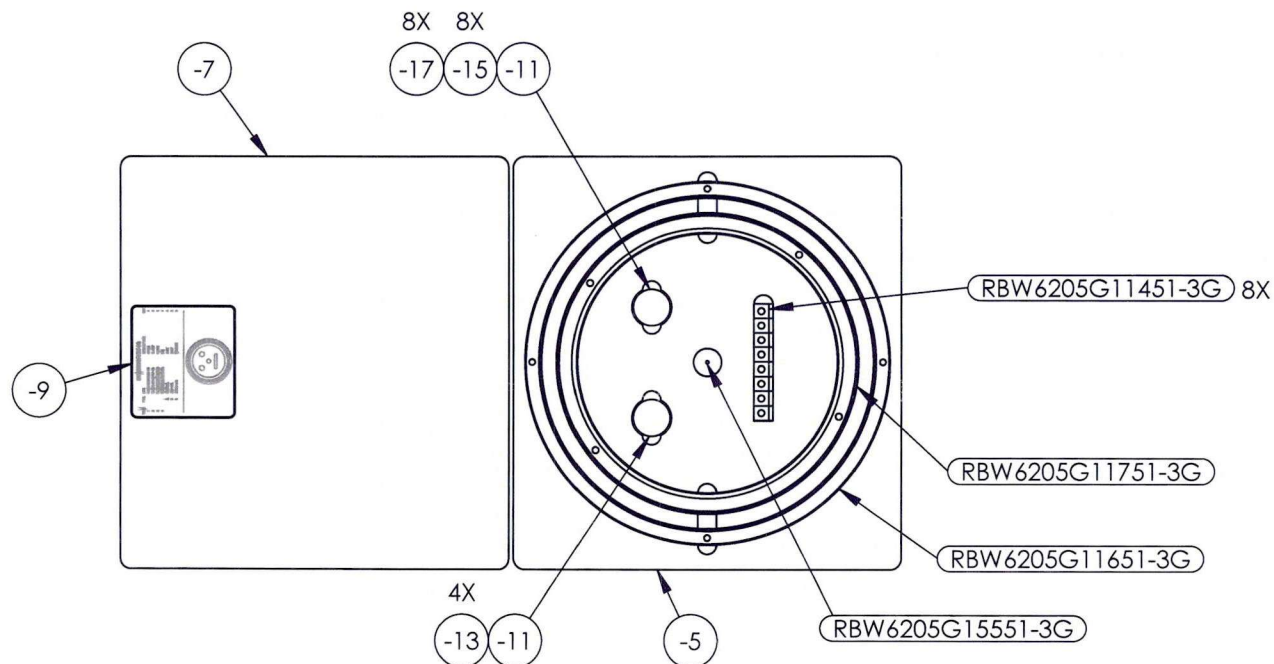
Part Specifications

Specifications could not be found.

Plex 1/29/19 8:42 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 ADDED FINGER CUTOUTS. -7 CH'D PLACARD CUTOUT TO RECESSED, CH'D MATERIAL WAS EGGSHELL IS C200 FLAT.	5/24/2011	RJC	RW
1	15-0175	-7 CH'D MATERIAL WAS C200 FLAT IS Y20 BLACK. -9 DELETED CONTENT LIST FROM PLACARD. -19, -21, & -23 ADDED TO BOM.	7/17/2015	RJC	JAG



SHOP COPY
 PLACARD TO
 ENGINEER G
 UNCORRECTED COPY
 SUBJECT TO APPROVAL
 WORK IN PROGRESS
 NO. 189620 MWS
 190122

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GUIDE		RBW6205G11651-3G	1
				8	CLAMP		RBW6205G11451-3G	1
				1	GUIDE		RBW6205G11751-3G	1
				1	PIN	W1 TOOL STEEL	RBW6205G15551-3G	1
		B/O	-3	1	CASE	PLASTIC, BLACK	11.40 X 21.10 X 22.50 PELICAN STORM IM2875-E	N/S
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	9-1/2 X 21 X 22-1/2 IR SPECIALTY FOAM	2
		B/O	-7	1	LID FOAM	Y20 BLACK	2 X 21 X 22-1/2 IR SPECIALTY FOAM	3
			-9	1	INSIDE PLACARD	PLASTIC		4
		B/O	-11	2	CUP	CLEAR PLOYSTYRENE	Ø1.77 X 4.02 (MCMaster-CARR #4611T26)	1
		B/O	-13	4	BOLT	STEEL	AN5-27A	1
		B/O	-15	8	BOLT	STEEL	AN5-10A	1
		B/O	-17	8	WASHER	ALUMINUM	AN960-516	N/S
		B/O	-19	1	DART PLACARD	ALUMINUM	#RB41011	N/S
		B/O	-21	4	RIVET	ALUMINUM	Ø1/8 X .525 (MCMaster-CARR #97447A130)	N/S
		B/O	-23	4	BLIND RIVET WASHER	ALUMINUM	Ø1/8 (MCMaster-CARR #90183A213)	N/S

NOTE:
 REF. AGUSTA T/N: 3G6205G15231.
 PART OF KIT RBW6205G11231-3G.

TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G15231-3G	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED: D Weil HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:10	DATE 1/31/2011
SHEET 1 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							